

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029892**Date Inspected:** 31-Jul-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Salvador Merino**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

FW Spencer:

At various panel points this QA randomly observed the FW Spencer welder, Tim Esquivel, continuing to perform the Complete Joint Penetration (CJP) welding using the Shielded Metal Arc Welding (SMAW) process to weld the root pass to cover pass on the 2.5" diameter domestic water line field butt joints. The welders were noted welding the root pass with the 3/32" diameter E6010 electrode and followed by the welding of the fill pass to cover pass using 3/32" diameter E7018H4R electrode implementing the FW Spencer WPS 1-12-1. The welders were noted preheating and removing the moisture of the joint using a portable propylene gas torch prior welding. During welding, ABF QC Salvador Merino was noted on site monitoring the parameters of the welders. At the end of the FW Spencer shift, CJP welding on the 2.5" diameter pipe joints at various locations were completed as noted below:

1. 91/2.5/119/BE Domestic water line
2. 92/2.5/119/BE Domestic water line
3. 93/2.5/119/BE Domestic water line
4. 94/2.5/119/BE Domestic water line

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

At W2 panel point PP117 Northwest, FW Spencer welders Salvador Gomez and Barry Mullaney were noted cutting the 2.5" and 4" diameter pipes and getting ready to install the tie-in pieces. There was no welding work performed by both welders during the shift.

At Kloeckner Metals of Oakland, CA, this QA performed a green tag release on 1 5/8" and 7/8" thick 6" x 4" Charpy V test specimens to be sent to Anamet Laboratory. The two materials are ASTM A572 grade 50 that were previously signed "Ok to cut" by another QA inspector. For more details on this green tag release, please see the TL-6011 report generated on this date.



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
----------------------	-------------------	-----------------------------

Reviewed By:	Reyes, Danny	QA Reviewer
---------------------	--------------	-------------
